

Date: Monday, 6/5/2006 8:59:09 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHORT STEP ASSEMBLY
Job Number	: 27395		
Estimate Number	: 11672		
P.O. Number	: N/A	Part Number	: D350591121
This Issue	: 6/5/2006	Drawing Number	: D2351 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E
Previous Run	: 26911	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 6/27/2006
Checked & Approved By	: _____	Qty:	4 Um: Each
Comment	: Est Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP K J/RF est rev. F 06.02.23 added grinding EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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* Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-121CHG003

KS 06.06.19

(4)

2.0	D2244116	Step Extrusion
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Comment: Qty.: 0.5000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
0.5	D2244-128	Extrusion	323404

LE 06.06.5 4

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244-128 extrusion to '55.32" long as per Dwg.D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr

LE 06.06.5 4

LE 06.06.5 4

LE 06.06.5 4

(PTO)

4.0	BENDING	BENDING MACHINE
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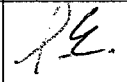






Comment: BENDING MACHINE

Bend per Dwg D2351 using Bend Program D23561dd FT011

DP 06-06-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-06-06	3	Fit no good in the sig. Step too short, leaving a gap between lug (Aft) and the step on one side.		Scrap: destroy: replace of Qty 3 steps. Bench will Also be modified for a better fit.	 06-06-22	 06-06-23	 06-06-23	 06-06-06

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/23

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Part Number: D350591121

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-06-09 (4)

6.0

D28501

End Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2850-1 End Bracket 39906

BE 06-06-10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Fwd and Aft end for welding

2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033

A/R Aluminum Rod M15689
M19173

3-Do not Grind Flush

BE 06-06-10

BE 06-06-10

BE 06-06-10

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M. 06/06/14

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-06-15 (4)

10.0

D2582

Hi-Skid Step Leg Ass'y

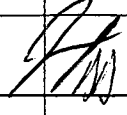
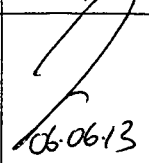




Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)


Pick:

Qty Part Number Description Batch
1 D2582 Step Leg Assy 225395

BE 06-06-15 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-06-13	7.1	QCS/9 Inspect work & weld.		06/06/13	4		
		Add  permanent change 					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/13

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Part Number: D350591121

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W3 Rivet

m13767

LC. 06.06.15 4

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet Leg Assembly as per Dwg D2351

LC. 06.06.15 4

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

100606-16

14.0

D267334

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2673-34 End Plate

B25396

LC. 06.06.16 4

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd End Plate per QSI 004 & Dwg D2351

A/R

Aluminum Rod

m19123

LC. 06.06.16 4

2-Grind end cap flush per dwg D2351

LC. 06.06.16 4

16.0

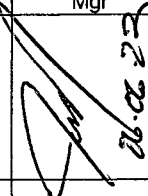
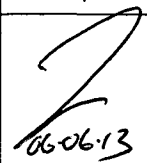
QC5

INSPECT WORK TO CURRENT STEP




Comment: INSPECT WORK TO CURRENT STEP

100606-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-06-13	16	Add QC 9 to QC 5. permanent change.				 06-06-23	 06-06-13	

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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/23

NOTE: Date & initial all entries

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Job Number: 27395

Part Number: D350591121

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Touch up Alodine

DL 06/06/14 (4)

18.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/19 (4)

19.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Wing Walk per Dwg D2351 and QSI 005 4.4
Batch: 1700266

FC 060619 (4)

20.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/06/19 (4)

21.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

22.0 D22301 Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch
1 D2230-1 Mounting Lug B25564 3mly
B23724 1mly

23.0 D22303 Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch
1 D2230-3 Mounting Lug B26593

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number: 27395

Part Number: D350591121

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 2.4000 f(s)

Pick:

Packing KitQty Part Number Description Batch

1 D2856-400 7.20" Abrasion Strip B25656 ✓

25.0

AN337A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

2 AN3-37A Bolt M13719 ✓

26.0

AN413A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

AN4-13A

Batch: M101149 ✓

27.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

4 AN960JD10 Washer M100743 ✓

28.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

6 AN960JD416 Washer M100575 ✓

29.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

2 MS21042L3 Nut (or -3) M100393 ✓

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Job Number: 27395

Part Number: D350591121

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

MS21042L4

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

3 MS21042L4 Nut (or -4) M19085

26/6/19 (4)

31.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

26/06/19 (4)

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-121

Location:

PPP Rev: C

26/06/19 (4)

33.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

26/06/22 (4)

Job Completion



U 26.06.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____